

## BUSHING/TUBE/GUIDE/THREADED LUG

### General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam  
76630 – Bell 206L/407 High Mounting Beam  
78633 – Airbus AS350 Aft Beam  
78634 – Airbus AS350 Forward Beam  
49215 – Lid Prop Bushing  
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop  
94023 – Airbus AS350 XL Attachment Hoop  
82715 – Airbus AS350 Short Step Assembly  
82733 – Airbus AS350 Short Step Bracket  
36274 – Handle Lever Bushing  
36275 – Handle Support and Bushing

Work Order: 2017-122

Batch Quantity: ~~200~~ 344 JC

**Complete**  
(initial or SCA #)

Date Open: 21 July 2017

Part Number: 36275-01

#### 1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 16043

AD  
73-04  
02

#### 2. Turn stock material:

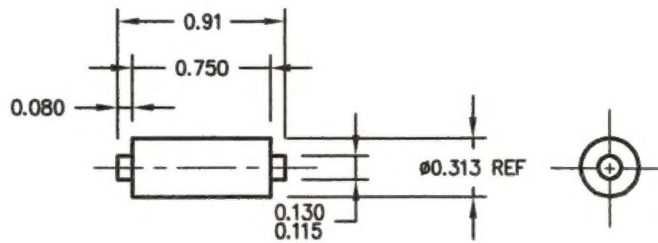
**CAUTION:** Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

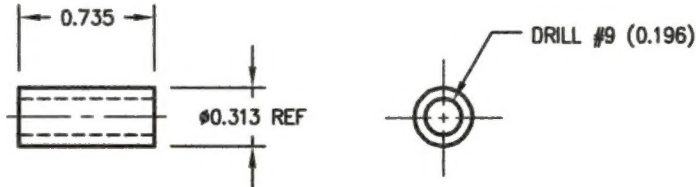
Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36210	STF	MAY 17/02
1	ADDED PART 02. BUSHING WAS STAINLESS STEEL	STF	JUN 03/04
2	DIMENSIONS UPDATED	BJC	JAN 8/07
3	LENGTHS CHANGED	BJC	NOV 03/09
4	TITLE BLOCK UPDATED, MATERIALS CHANGED	BJC	04/10/2013



(02) SUPPORT




(01) BUSHING

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.

36275-02	01	SUPPORT	304 STAINLESS STEEL	ASTM A479	5/16" ROD
36275-01	01	BUSHING	360 BRASS	ASTM B16	5/16" ROD
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY	LIST OF MATERIALS
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THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.	APPROVALS DRAWN: STEVEN FAHEY CHECKED: E. BURGOIN	DATE MAY 17/02 MAY 01/03	 <b>AERO DESIGN LTD.</b> 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca	<b>HELICOPTER CARGO BASKET HANDLE BUSHING AND SUPPORT</b>		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS      ANGLES X.XXX ±0.010      ±1/2° X.XX ±0.03 X.X ±0.1					
	SCALE 1 : 1 SHEET 1 OF 1		DWG. SIZE <b>A4</b>	DWG. NO. <b>36275</b>	REV. <b>4</b>	



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

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AMF 73-04

Nomenclature: BUSHING No. of pieces: 344

Manufacturer: AERO DESIGN LTD.

Part No.: 36275-01 Serial/Batch No.: P016043

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-122

Remaining Tasks to be Performed: TURN END, DRILL, TURN FAR END  
INSPECT

Signature: [Signature]

Date: 22 AUG 2017 Lic. No. / SCA A202

In Process





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AMF 73-04

**In Process**

**Remarks**

-1 RED TAGGED JC. - TOO SHORT



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AMF 73-04

Unserviceable

### Remarks

PART SCRAPPED 20 NOV 2017 JC



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AMF 73-04

Nomenclature: 36275-01

Manufacturer: Aero Design Ltd

Part No.: 36275-01 Serial / Batch No.: PO 16043

TTSN: N/A TSO: N/A Rem.: N/A

Removed From: 2017-122

Reason For Removal: cut too short

A/C Hours at Removal: \_\_\_\_\_ WO.# \_\_\_\_\_

Signature: \_\_\_\_\_

Date: 17 Nov 2017 Lic. No. / SCA \_\_\_\_\_

Unserviceable

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2018-0068
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice N/A
6. Item 1.	7. Description Bushings	8. Part Number 36275-01	9. Qty. 2	10. Serial/Batch No. WO 2017-122	11. Status/Work New
12. Remarks Certification data: TCCA STC SH08-16, FAA STC SR02680NY					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.</del>		
13b. Signature <i>Jeff Clarke</i> AD 73-04 02		13c. Approved Organization Number AMF 73-04		<del>14b. Signature</del>	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 06 Apr 2018		<del>14c. Approved Organization Number</del>	
				<del>14d. Name</del>	
				<del>14e. Date (dd/mm/yyyy)</del>	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.          Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.          Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

HEU QWEST